

Work Order ID 52444

September 23, 2009 3:42:19 PM



Page 1

Item ID: PB67-43001-29 *DG*

Accept



Setup Start



Revision ID: B1

Stop



Item Name: PB67-43001-29 Blade Positioner Weldment

Start Date: 09/28/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-09-23* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001

Rev B1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

****FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG. MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO WELDING****
11- ASSEMBLE AND WELD AS PER DWG

09-09-25

2 *Ø*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 *Ø* *BE 09/09/25*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ See 09/09/25

(12) *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

M 09/09/30

X2 0

Hand Finishing

140

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

M 18144
09/10/02

X2 0

Powder Coating

START TIME:

9:30am

OVEN TEMPERATURE:

10:00am FINISH TIME:

320°F

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

BR 09-10-2

2

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Cust Item ID:

Required Date: 10/05/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

9/10/2 2xgy

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/05
mf 09-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

September 23, 2009 3:42:19 PM

Page 1

Work Order ID: 52444

Parent Item: PB67-43001-29RevB1

Parent Item Name: PB67-43001-29 Blade Positioner Weldment

Start Date: 09/28/2009

Required Date: 10/05/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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PB67-43001-313RevB1 Manufactured No



Plate

2.0000



09.09.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

41503

6

44968

1

PB67-43001-319RevB1 Manufactured No



Gusset

100

Each

19.0000

4.0000



09.09.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

44967

19

PB67-43001-337RevB1 Manufactured No



Upper Pad Assembly

100

Each

19.0000

4.0000



09.09.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

44966

19

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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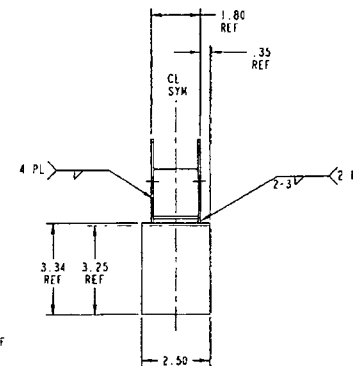
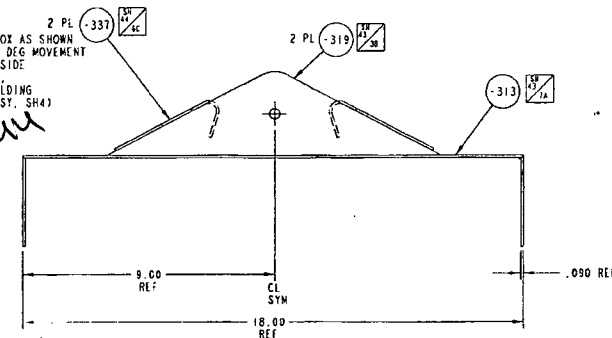
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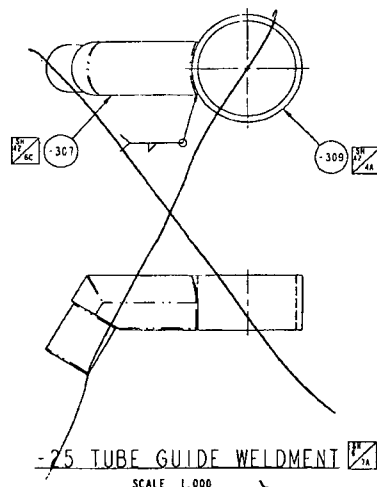
RELEASED

LOCATE APPROX AS SHOWN
ASSURING 45 DEG MOVEMENT
OF -285 EA SIDE
OF VERTICAL
PRIOR TO WELDING
(SEE -27 ASST, SH4)

#52444

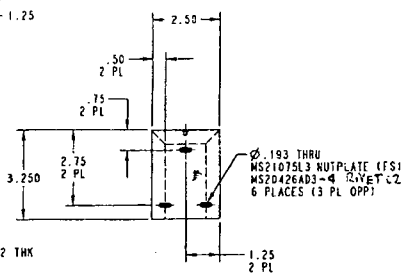
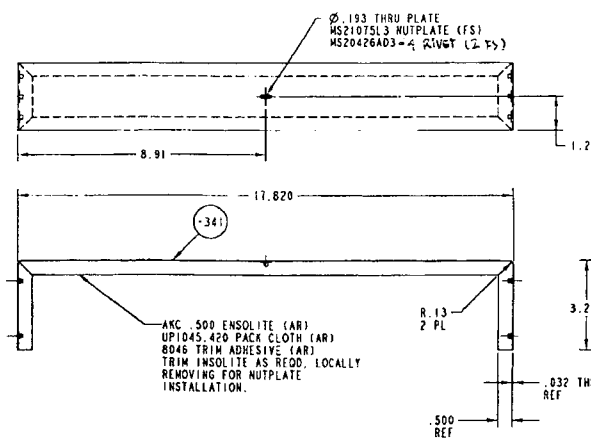


① -29 BLADE POSITIONER WELDMENT
SCALE 0.500



-25 TUBE GUIDE WELDMENT
SCALE 1.000

SUPERCEDED BY
D3440-1 & D3440-3



① -35 LOWER PAD ASSY
SCALE 0.500
DATE FOR -341: .032 THK 2024-13, 00-A-250/4

PREMIER AVIATION, INC.	
2001 Aviation Parkway, Grand Prairie, Texas 75052	
FILE NO. D3440-1	REV. NO. 51
SCALE: 1:1	SHEET: 40 OF 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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